

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018818**Date Inspected:** 18-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG COMPONENT	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 12AW to 12BW weld No.OBW12-001. The welder is identified as #044560. ZPMC QC is identified as Mr. Wang Zhu. The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-ESAB.

SMAW in the 4G position for the OBG Segment 12AW weld No.SEG3004A-004. The welder is identified as #046709. ZPMC QC is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG Segment 12AE weld No.SEG3001AA-022. The welder is identified as #050289. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Ultrasonic Testing (UT) at Bay#10

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as bike path weld joint.

The weld designation reviewed is as follows:

BK004-A5-032-002,008

BK004-A3-032-002,010

Ultrasonic Testing (UT) at Bay#10

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as tower weld joint.

The weld designation reviewed is as follows:

SSD1-FFSA6-1-23

Ultrasonic Testing (UT) at Bay#11

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as tower weld joint.

The weld designation reviewed is as follows:

SD1-BRSA5-1-001,002,003,004,005,006,007,008,009,010

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Tower Lift-5 Bracket at bay#11, this Quality Assurance Inspector (QA) discovered the following issues One longitudinal linear Class "A" rejectable indication measuring approximately 20mm in length. The indication db rating is a +3. Material thickness is 50mm. The depth of the indication is approximately 28mm. The weld is identified as SD1-BRSA5-1-19. The weld is Complete Joint Penetration (CJP) "T" joint joining Web BR5-2(PL50) to flange BR5-7(PL22). The indication is clearly marked on or near the weld. The Y distance for this indication is 570 mm from edge of the bracket. The tower bracket is located at bay#11. The Notice of Witness Inspection (NWIT) No. is 07818. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

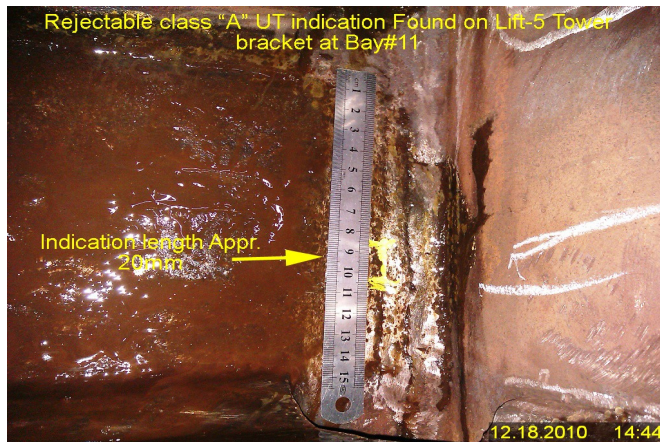
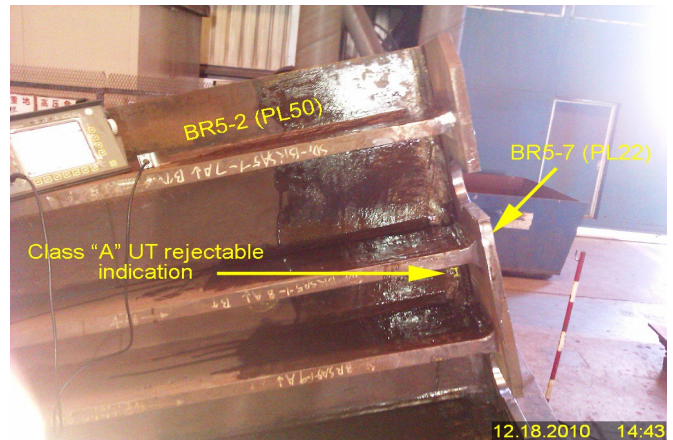
This QA inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer